

ship Sept. 30

Work Order ID 73019

Wednesday, August 24, 2011 8:52:41 AM



Item ID: D350-591-311

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Long LH

Start Date: 8/24/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 9/30/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3272

Rev B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

5 11/09/123

Handwritten signature and date: BG 11-9-22

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/R Aluminum Rod

3-Grind End Plate flush

Handwritten numbers: 114514, 117884

Handwritten date and time: 11.09.14 10:00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Date:

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Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

* 10 0 2E11/09/14

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/11/09/15

10
LH

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

11.09.15

10 0

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Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10 BL 11-9-15

180

Large Fab

0.00



Large Fab

Memo

0.00

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272
A/R III Aluminum Rod 114514

6-Grind End Plate flush

7-Install last rivet as per Dwg.

Ac 11-09-17

11-09-20

X10

Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Reference:

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Tooling: Date:

Run Start

QC: Date:

SPC (Y/N): Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

210

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10X4 M-11/09/21
LHX

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Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:45
320°F
12:15

0.00

10X8 M-11/09/21
LH

230

Wing Walk as per dwg QSI005 4.4 Batch 118313

0.00



HandFinish

Hand Finishing

Memo

0.00

10 LH. BL 11.9.21.

240

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

-10 LH. 11/09/21

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Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____

QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00							
Quality Control									
270	Packaging	0.00							
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-591-311								
	Location: <u>HAN</u>								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

n/a/27

mf
11-09-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Wednesday, August 24, 2011 8:52:38 AM

Page 1

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Parent Item Name: Heli-Access-Step, Long LH

Start Date: 8/24/2011

Required Date: 9/30/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A: 04.03.22 New issue 11KJ/RF
 IPP Rev:B 07-06-09 Added D3272-1 JLM
 IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC
 IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3272-1 Step		Manufactured	No			110	Each	10.0000	1	10		11.09.13	
-----------------	--	--------------	----	--	--	-----	------	---------	---	----	--	----------	--

Location	Loc Qty	Loc Code
WA 373025	10	
71963	10	

D3067-1 End Plate		Manufactured	No			110	Each	54.0000	1	10		11.09.14	
----------------------	--	--------------	----	--	--	-----	------	---------	---	----	--	----------	--

Location	Loc Qty	Loc Code
WA	53	
67582	2	
70700	51	
WA016	1	
68214	1	

D3219-1 Plate		Manufactured	No			110	Each	88.0000	2	20		11.09.14	
------------------	--	--------------	----	--	--	-----	------	---------	---	----	--	----------	--

Location	Loc Qty	Loc Code
WA	48	
72128	48	
WA017	40	
68338	40	

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Page 2

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Parent Item Name: Heli-Access-Step, Long LH

Start Date: 8/24/2011

Required Date: 9/30/2011

Start Qty: 10.00

Required Qty: 10.00

D3066-1 Manufactured No
Spacer

180 Each

87.0000

2 20

Location

Loc Qty

Loc Code

WA

87

70699

87

180 Each

1,520.000

16

MS20600-AD4W4 Purchased No
Rivets

Location

Loc Qty

Loc Code

ST321

1515

116188

59

117364

1000

117601

200

117885

195

~~118267~~

~~10~~

WA018

5

116712

5

D3065-041 Manufactured No
Step Leg Assembly Hi

180 Each

0.0000

1 10

D3067-1 Manufactured No
End Plate

180 Each

54.0000

1 10

Location

Loc Qty

Loc Code

WA

373404

53

67582

2

70700

51

WA016

1

68214

1

Ac 11.09.17

x20
160

Ac 11.09.17

x125
x35

B70778 x10 Ac 11.09.17

Ac 11.09.20

10

Wednesday, August 24, 2011 8:52:38 AM

Shop Packet Print

Page 2

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item Name: Heli-Access-Step, Long LH

Start Date: 8/24/2011

Required Date: 9/30/2011

Start Qty: 10.00

Required Qty: 10.00

AN3-35A

Purchased

No

250

Each

157.0000

2

20



Bolt



SP

Location

Loc Qty

Loc Code

ST353

157

117619

3

117794

14

118112

40

118451

50

118628

50

D3235-1

Manufactured

No

250

Each

177.0000

2

20



Mounting Lug



SP

Location

Loc Qty

Loc Code

ST471

77

69837

77

ST481

100

71965

100

D3278-041

Manufactured

No

250

Each

26.0000

1

10



Support Assembly



SP *BRB*

Location

Loc Qty

Loc Code

ST471

26

69741

26

AN960JD416

NAS1149D0463J

Purchased

No

250

Each

0.0000

16

160



Washer



SP

AN960JD516

NAS1149D0563J

Purchased

No

250

Each

0.0000

4

40



Washer



SP *11-09-22*

Wednesday, August 24, 2011 8:52:38 AM

Shop Packet Print

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Page 4

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Start Date: 8/24/2011

Required Date: 9/30/2011

Start Qty: 10.00

Required Qty: 10.00

AN5-36A

Purchased

No

250

Each

157.0000

2



Bolt

Location

Loc Qty

Loc Code

ST341

157

117794

7

118012

50

118451

100

D2618

Manufactured

No

250

Each

132.0000

2



Bushing

Location

Loc Qty

Loc Code

ST019

132

70702

28

71600

104

D2230-3

Manufactured

No

250

Each

304.0000

4



Lug

Location

Loc Qty

Loc Code

ST

220

70694

20

71964

100

72125

100

ST476

4

53881

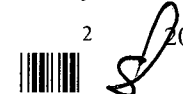
4

ST480

80

70973

80



20

Bm118 838.5x



20

5x



40

Sp 11-09-22

10x

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Parent Item Name: Heli-Access-Step, Long LH

Start Date: 8/24/2011

Required Date: 9/30/2011

Start Qty: 10.00

Required Qty: 10.00

D2856-400

Manufactured No

250 F

254.7845 1.2 12



Abraison Strip

SP 11-09-22

Location

Loc Qty

Loc Code

ST403

38.1149

68076

38.1149

ST409

216.6696

63735

0.6696

71164

216

12x

*** cut (2) at 7.20" (D2856-400-720) ***

MS21042L3

Purchased No

250 Each

1,835.000 2



Nut

SP 11-09-22

Location

Loc Qty

Loc Code

ST300

1835

117441

190

117601

400

117885

245

118451

1000

20x

AN4-13A

Purchased No

250 Each

1,006.000 8



Bolt

SP 11-09-22

Location

Loc Qty

Loc Code

ST357

1006

117962

4

118078

594

118350

108

118351

300

80x

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Required Date: 9/30/2011

Start Qty: 10.00

Required Qty: 10.00

MS21042L5

Purchased

No

250

Each

1,153.000

2

20



Nut



SP 11-09-22

Location

Loc Qty

Loc Code

ST300

1153

116105

5

116548

53

117441

494

117591

15

117611

90

118179

496

20x

MS21042L4

Purchased

No

250

Each

4,539.000

8

80



Nut



SP 11-09-22

Location

Loc Qty

Loc Code

ST300

4539

117441

394

117601

645

117885

1500

118451

2000

80x

AN960JD10

NAS1149D0363J

Purchased

No

250

Each

0.0000

4

40



Washer



SP 11-09-22

m118077 40x

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DESIGN <i>GP</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04 *[Signature]*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

△
B

GENERAL NOTES:

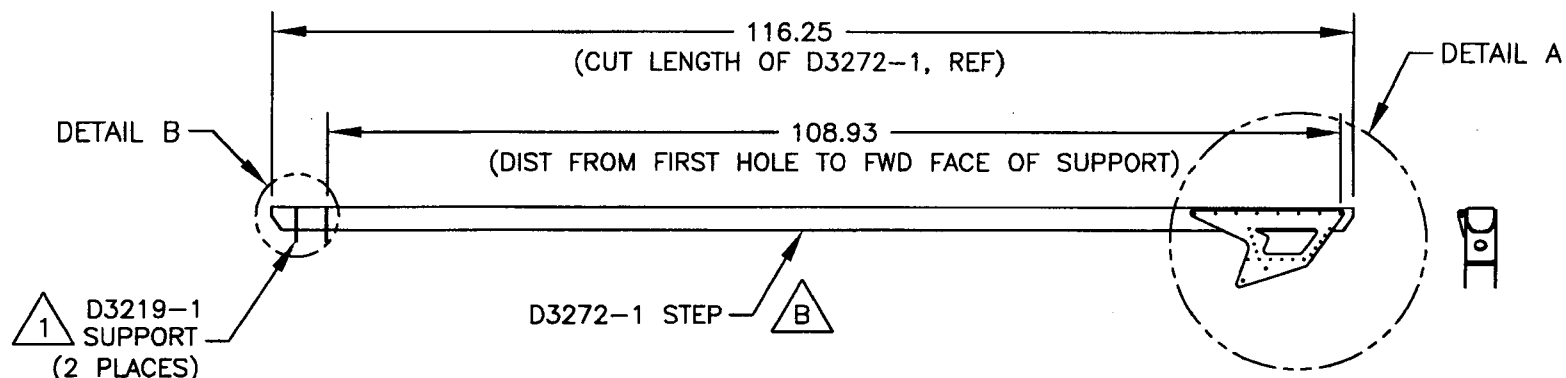
- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

7329

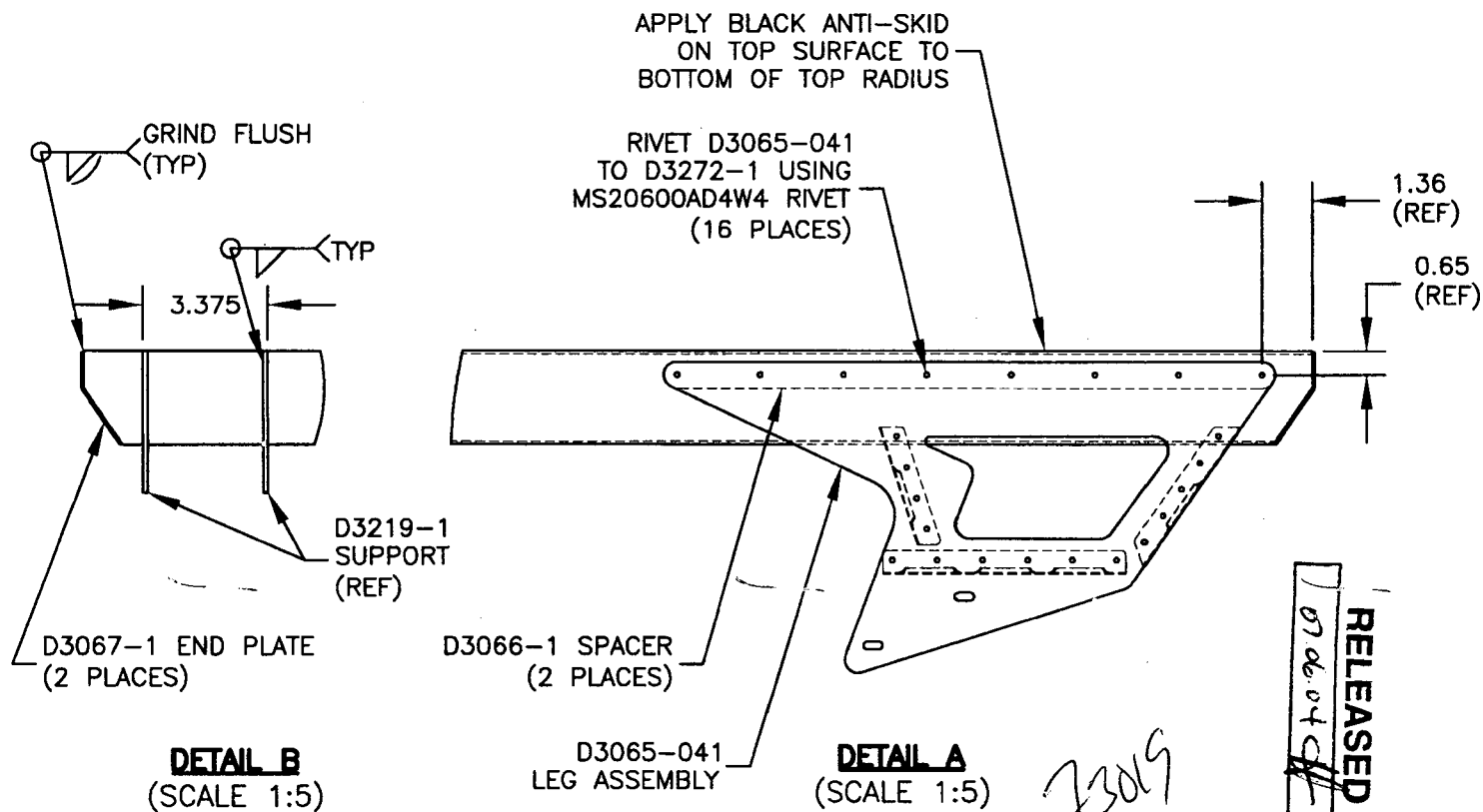
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DART



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



RELEASED
07.06.04

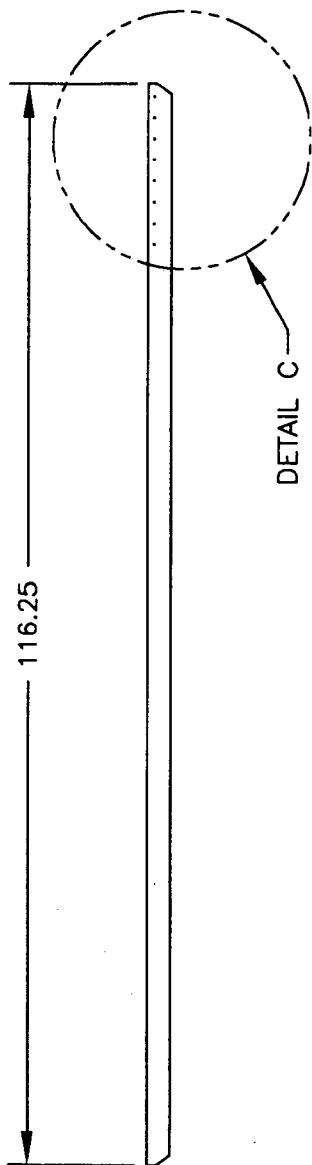
DESIGN 90	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. B
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3272	SHEET 2 OF 3
DATE 07.05.18	TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20	



DESIGN <i>qp</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED

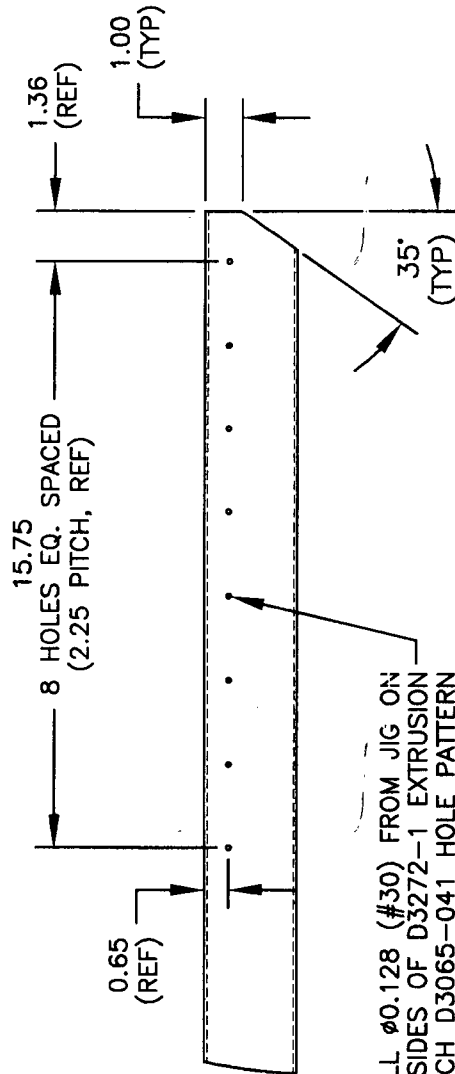
07.06.04 *[Signature]*



DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



left

DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C

(SCALE 1:5)

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Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™ , Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™ , Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™ , Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™ , Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™ , Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™ , Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™ , Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™ , Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.